

Date: Wednesday, 10/3/2007 8:38:49 AM
 User: Kim Johnston

Process Sheet

44

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP STRUT
Job Number	: 34983		
Estimate Number	: 11945		
P.O. Number	: N/A	Part Number	: D2017131
This Issue	: 10/3/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2017 REV E1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33209	Drawing Revision	: E1
		Material	: N/A
Written By	: <u>1/8 07/10/03</u>	Due Date	: 10/30/2007
Checked & Approved By	: <u>1/8 07/10/03</u>	Qty:	6 Um: Each
Comment	: Est F 02.06.19 Update processes (Ref. ECN 435) KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.7738 f(s)/Unit Total: 16.6427 f(s)

Punch tube type 304-2B, 3/4" Ø. X .049" wall to length per Dwg. D2017 & spec control D2638

Batch No. M105732

SB 07/10/17 (6)

Deburr

SAD 07/10/20 (6)

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Er 07/10/22 (6)

3.0	POWDER COATING	POWDER COATING
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M105068



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-k 07/10/22

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

7/10/22 SP 6x

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 258

7/10/22 SO (6x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 07/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:38:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 34983

Part Number: D2017131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/10/23

Job Completion



U 08/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

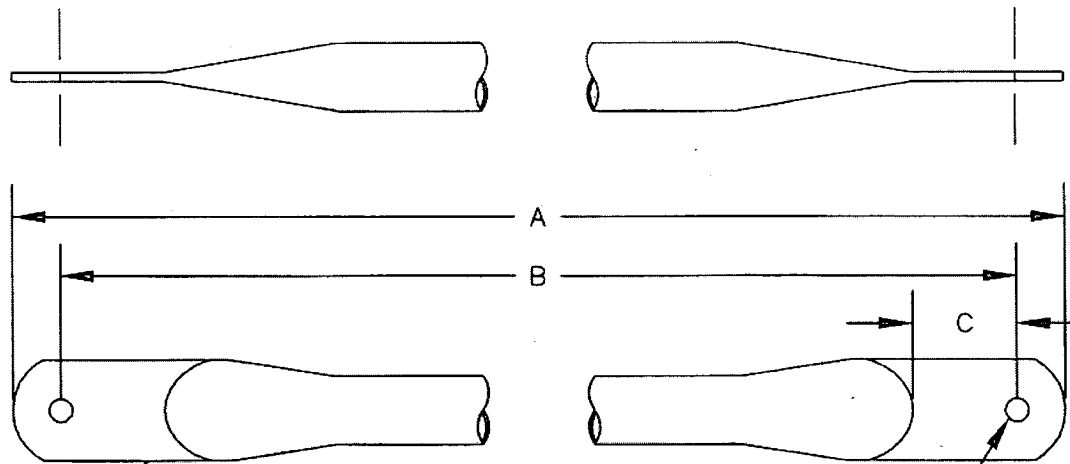
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
99.05.11 KE

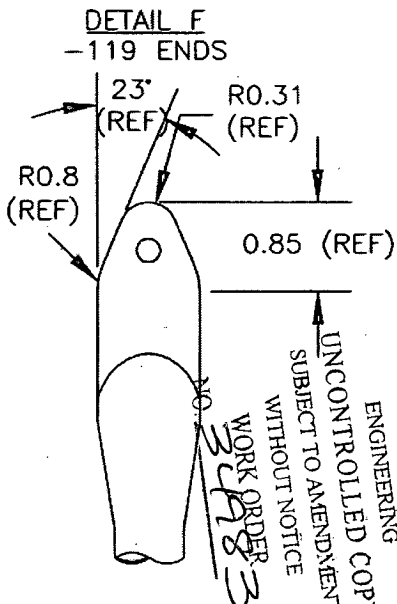


PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	RF	D2017
DATE	TITLE	SHEET 1 OF 2
99.04.16	STEP STRUTS	SCALE
		NIS
C	95.01.26	ADDED PARTS
D	96.03.28	ADD PARTS
E	99.04.16	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897)
E1	02.03.22	ADD FINISH

Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-



NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP/ 8° DOWN

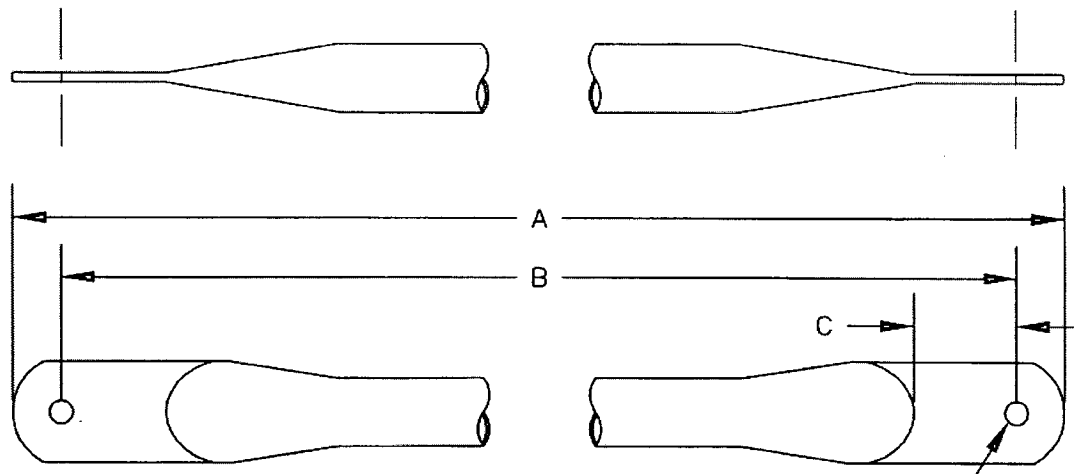
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 / E1



DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	
DATE	99.04.16	TITLE	D2017	REV. E
STEP STRUTS				SHEET 2 OF 2
				SCALE NTS

RELEASED
99.05.11 KE

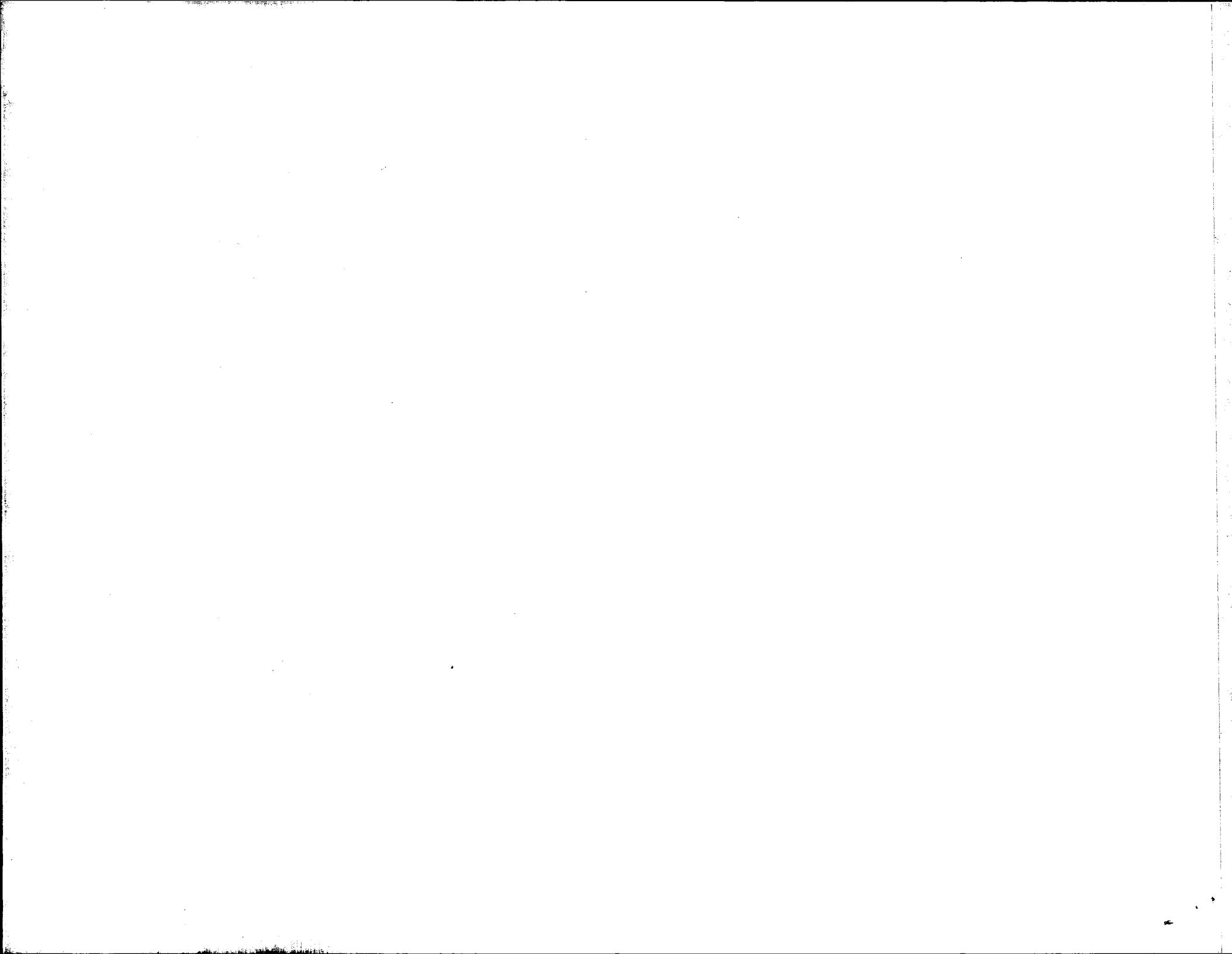


"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

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WITHOUT NOTICE
WORK ORDER
NO. 34983

NOTE:
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 / EI

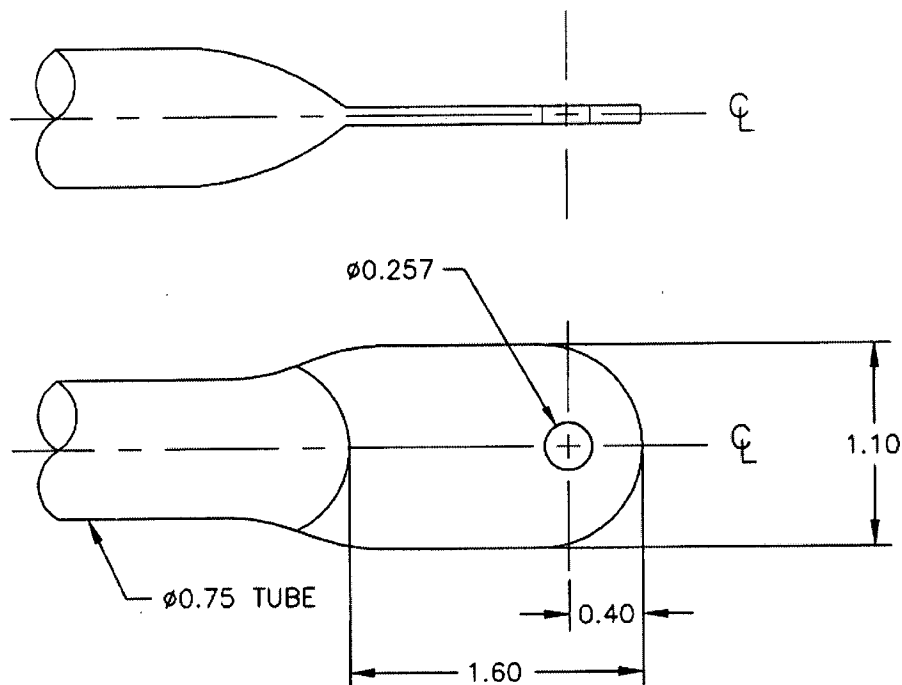




DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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NO. 34983